Work Order ID 65086

Thursday, January 06, 2011 9:55:47 AM

Item ID: D2744 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Cap

Start Date: 1/6/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 1/13/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 1-04-6 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2744	Rev C

100 — 0.00

Waterjet

FLOW WATER JET

Memo 0.00

1-Cut as per Dwg D2744
Dwg Rev: C
Prog Rev: C
2-Deburr if necessary

FLOW CNC Waterjet

5053 .080

RH-1-11 (29)

110 — QC2- Inspect parts off machine FAI/FAIB — 0.00

QC

Quality Control

Memo 0.00

RH-1-11

120 — QC8- Inspect parts - second check — 0.00

QC

Quality Control

Memo 0.00

Sulaiha

counter

XZ9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65086

Thursday, January 06, 2011 9:55:47 AM

Item ID: D2744 **Accept** **Setup Start**

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Item Name: Cap

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: LG	0.00							
Packaging						x29	0	BE	11/01/12
Packaging	**Memo** ***STOCK IN SKIDTUBE CELL***	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
QC									11/01/12
Quality Control	**Memo**	0.00							

MF
11-01-12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 9:55:51 AM

Work Order ID: 65086

Parent Item: D2744

Parent Item Name: Cap

Start Date: 1/6/2011 **Required Date:** 1/13/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP □C□03.01.17□Reformat; Dwg revised□KJ/RF
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP Rev:E As per Rev C 07-07-28 JLM Verified By:□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080		Purchased	No			100	sf	86.7342	0.1823	3.837895			
5052-H32 .080 Sheet													

Location	Loc Qty	Loc Code
MAT22	86.7342	
100682	1.4	
100742	49.4	
100947	32.9342	
19729	3	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6508
Description: Cap	Part Number:	D2744
Inspection Dwg: D2744 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.02	+/-0.030	3.005	✓		V 1B02	
6.52	+/-0.030	6.513	✓		V	
3.26	+/-0.030	3.26	✓		V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	11-1-11	Date:	4/01/12	Date:	N/A

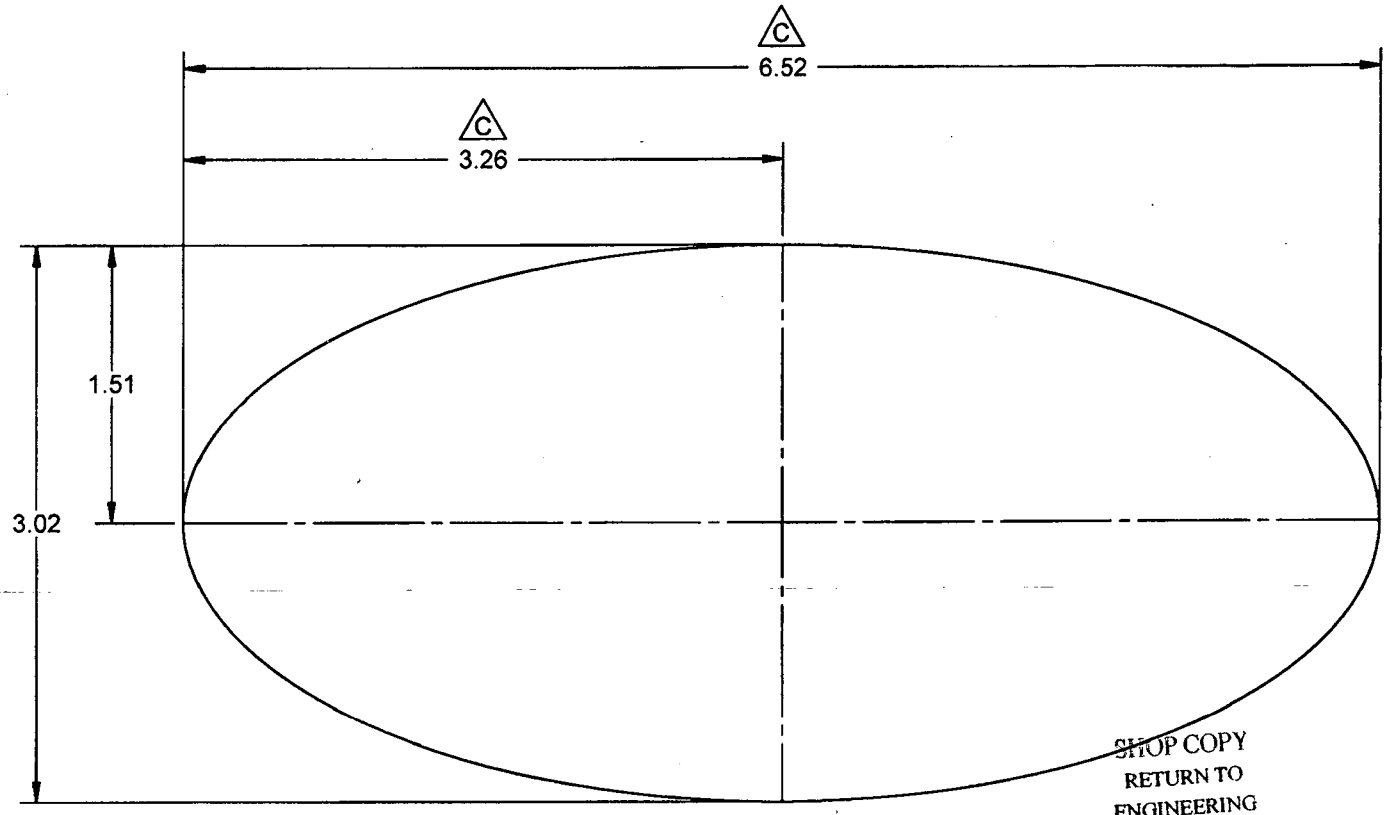
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.22	Dimension 6.52 was 6.27	KJ/RF	
C	07.09.06	3.26 dimension added	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP	SCALE 1:1

REV	DATE	DESCRIPTION
A	98.04.16	NEW ISSUE
B	02.12.18	RE-DESIGN
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27

RELEASED
07.08.02



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. G5084
11-01-6

D2744 CAP

NOTES:
1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS

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